

Work Order ID 142114

February 26, 2016 1:21:14 PM

142114

Page 1

To ship March 10.

Item ID: D3782-045 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Back Leg Assembly

Start Date: 3/4/2016 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 3/10/2016 Req'd Qty: 2.00 ***2*** Customer:

Reference:

Approvals: Process Plan: *Stb* Date: 20160226 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3782	Rev B

100	Pick Kit	0.00							
100									
Packaging	Memo	0.00				<u>2</u>	<u>FF</u>	<u>MAR 21 2016</u>	
Packaging									

110	Small Fab	0.00							
110									
Small Fab	Memo	0.01				<u>2</u>	<u>FF</u>	<u>MAR 21 2016</u>	
Small Fab	1-assemble as per dwg D3782								

120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00				<u>(2)</u>		<u>MAR 21 2016</u>	
Quality Control									

DAS
38
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 142114***142114***

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Item ID: D3782-045 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Back Leg Assembly
Start Date: 3/4/2016 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 3/10/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location	0.00				2			
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MLJ MAR 22 2016

MLJ MAR 22 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

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Work Order ID: 142114

142114

Parent Item: D3782-045

D3782-045

Parent Item Name: Back Leg Assembly

Start Date: 3/4/2016

Required Date: 3/10/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-05-19 new issue DD verified by:ec
IPP Rev:B 08-06-17 rev.A as per dwg DD verified by:EC IPP Rev:C
10.02.22 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3772-1 *D3772-1* Back Leg		Manufactured	No			110	Each	1.0000	1	2	DAS 30 9-89	MAR 2 1 2016	
				<u>Location</u>				<u>Loc Qty</u>			<u>Loc Code</u>		
				ST255				1			B 142115 ②		
					125191			1					
D3787-1 *D3787-1* Foot		Manufactured	No			110	Each	19.0000	1	2		MAR 2 1 2016	
				<u>Location</u>				<u>Loc Qty</u>			<u>Loc Code</u>		
				ST253				19					
					123684			19					
D3764-1 *D3764-1* Back Leg Fitting		Manufactured	No			110	Each	1.0000	1	2	DAS 30 9-89	MAR 2 1 2016	
				<u>Location</u>				<u>Loc Qty</u>			<u>Loc Code</u>		
				ST251				1			B 142124 ①		
					104909			1					
D3773-041 *D3773-041* Headrest Assembly		Manufactured	No			110	Each	5.0000	1	2		MAR 2 1 2016	
				<u>Location</u>				<u>Loc Qty</u>			<u>Loc Code</u>		
				ST252				5					
					141875			5					

Picklist Print

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Work Order ID: 142114

142114

Parent Item: D3782-045

D3782-045

Parent Item Name: Back Leg Assembly

Start Date: 3/4/2016

Required Date: 3/10/2016

Start Qty: 2.00

Required Qty: 2.00

D3786-1 Manufactured No

110 Each 10.0000 1 2

D3786-1

Sleeve

**

FF

MAR 2 1 2016

Location

Loc Qty

Loc Code

ST253

10

104917

10

2

AN45-15A

Purchased No

110 Each 7.0000 1 2

AN45-15A

EYE BOLT

**

FF

MAR 2 1 2016

Location

Loc Qty

Loc Code

GA

6

m127474

6

2

ST340

1

m129505

1

AN5-15A

Purchased No

110 Each 63.0000 1 2

AN5-15A

Bolt

**

FF

MAR 2 1 2016

Location

Loc Qty

Loc Code

GA

15

m132930

15

2

ST337

48

m132930

48

AN5-17A

Purchased No

110 Each 120.0000 1 2

AN5-17A

Bolt

**

FF

MAR 2 1 2016

Location

Loc Qty

Loc Code

GA

36

117872

36

2

ST337

84

m134055

84

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Shop Packet Print

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Work Order ID: 142114

Parent Item: D3782-045

Parent Item Name: Back Leg Assembly

142114

D3782-045

Start Date: 3/4/2016

Required Date: 3/10/2016

Start Qty: 2.00

Required Qty: 2.00

AN4-15A

Purchased

No

110

Each

199.0000

2

4

AN4-15A

Bolt

FF

MAR 2 1 2016

Location

Loc Qty

Loc Code

GA

40

120449

40

over003

100

m134055

100

ST343

59

m133284

3

m133769

56

MS21042L4

Purchased

No

110

Each

2,249.000

2

4

MS21042L 4

Locknut

FF

MAR 2 1 2016

Location

Loc Qty

Loc Code

FP001

41

m133363

41

GA

456

m133769

456

ST007

1500

m134055

1500

ST303

155

m133769

155

ST305

97

m130922

97

Picklist Print

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Work Order ID: 142114

142114

Parent Item: D3782-045

D3782-045

Parent Item Name: Back Leg Assembly

Start Date: 3/4/2016

Required Date: 3/10/2016

Start Qty: 2.00

Required Qty: 2.00

MS21042L5

Purchased

No

110

Each

523.0000

3

6

MS21042L5

FF

MAR 21 2016

Nut

Location

Loc Qty

Loc Code

GA

146

m127813

146

ST303

377

m134055

377

NAS1149D0463J

Purchased

No

110

Each

4,709.000

4

8

NAS1149D0463J

FF

MAR 21 2016

WASHER

Location

Loc Qty

Loc Code

GA

237

M129390

41

M132035

196

ST263

3124

M134039

3124

ST269

1348

M130799

360

M132317

100

M132677

888

Picklist Print

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Work Order ID: 142114

142114

Parent Item: D3782-045

D3782-045

Parent Item Name: Back Leg Assembly

Start Date: 3/4/2016

Required Date: 3/10/2016

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0563J

Purchased

No

110

Each

1,324.000

5

10

NAS1149D0563.J

MAR 21 2016

Washer

Location

Loc Qty

Loc Code

GA

309

m125807

14

m133769

295

ST263

912

m133363

14

m133938

11

m133990

387

m134257

500

ST269

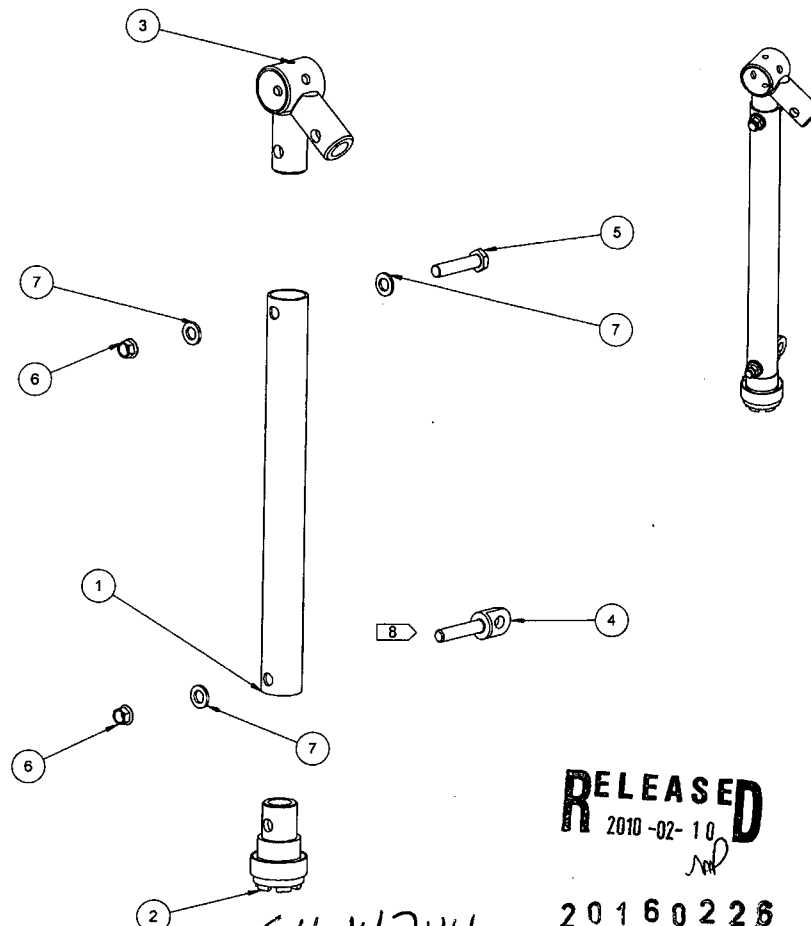
103

m128257

103

ITEM NO.	QTY. (-041)	PART NUMBER	DESCRIPTION
1	1	D3768-1	FRONT INBOARD LEG
2	1	D3787-1	FOOT
3	1	D3762-041	FRONT LEG FITTING ASSY
4	1	AN45-13A	EYE BOLT
5	1	AN5-13A	BOLT
6	2	MS21042L5	NUT
7	3	NAS1149D0563J	WASHER (AN960JD516)

△



D3782-041 FRONT INBOARD LEG ASSEMBLY

NOTES:

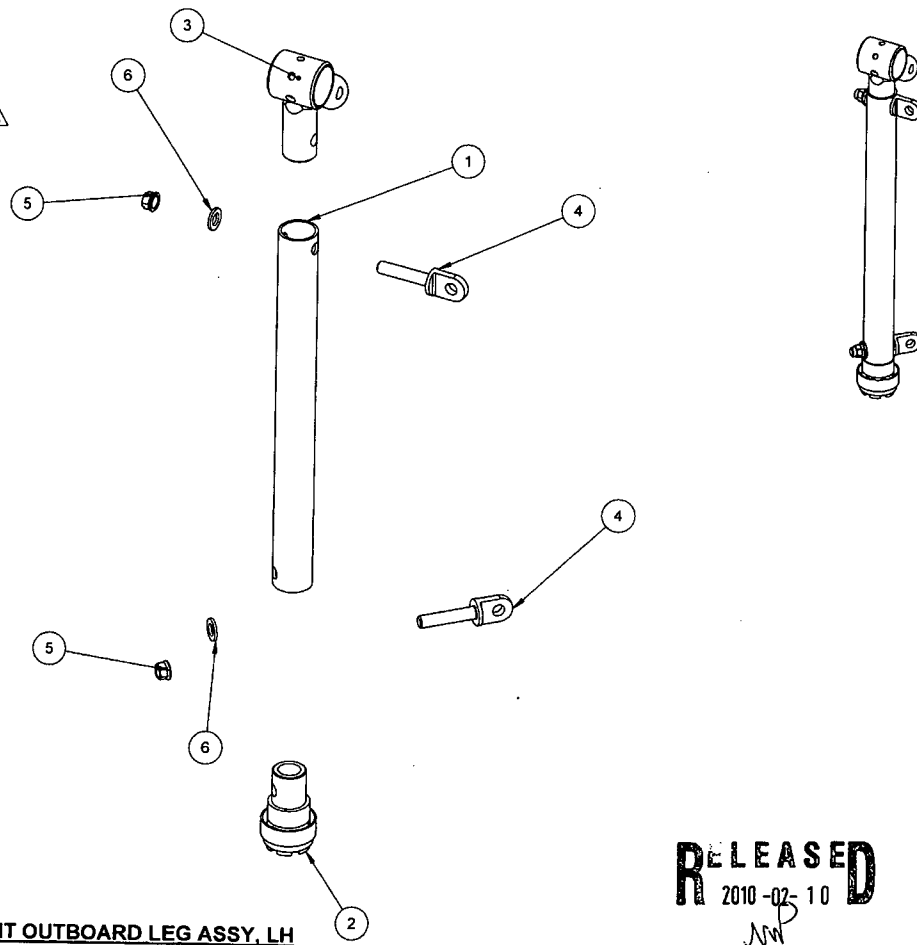
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs
- 8) ITEM 4 (AN45-13A EYE BOLT) INSTALLED AS SHOWN FOR D412-769-041 AFT FACING SEAT, LH
INSTALLED IN REVERSE FOR D412-769-042 AFT FACING SEAT, RH

RELEASED
2010-02-10

20160226

B	REVISE P/N NAS1149D0568J TO NAS1149D0563J ALL SHEETS, ZN D7	HS	10.01.21
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.01.21		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. B SHEET 1 OF 4 SCALE NTS	
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ITEM NO.	QTY. (-043)	PART NUMBER	DESCRIPTION
1	1	D3768-3	FRONT OUTBOARD LEG, LH
2	1	D3787-1	FOOT
3	1	D3762-041	FRONT LEG FITTING ASSY
4	2	AN45-13A	EYE BOLT
5	2	MS21042L5	NUT
6	2	NAS1149D0563J	WASHER (AN960JD516)



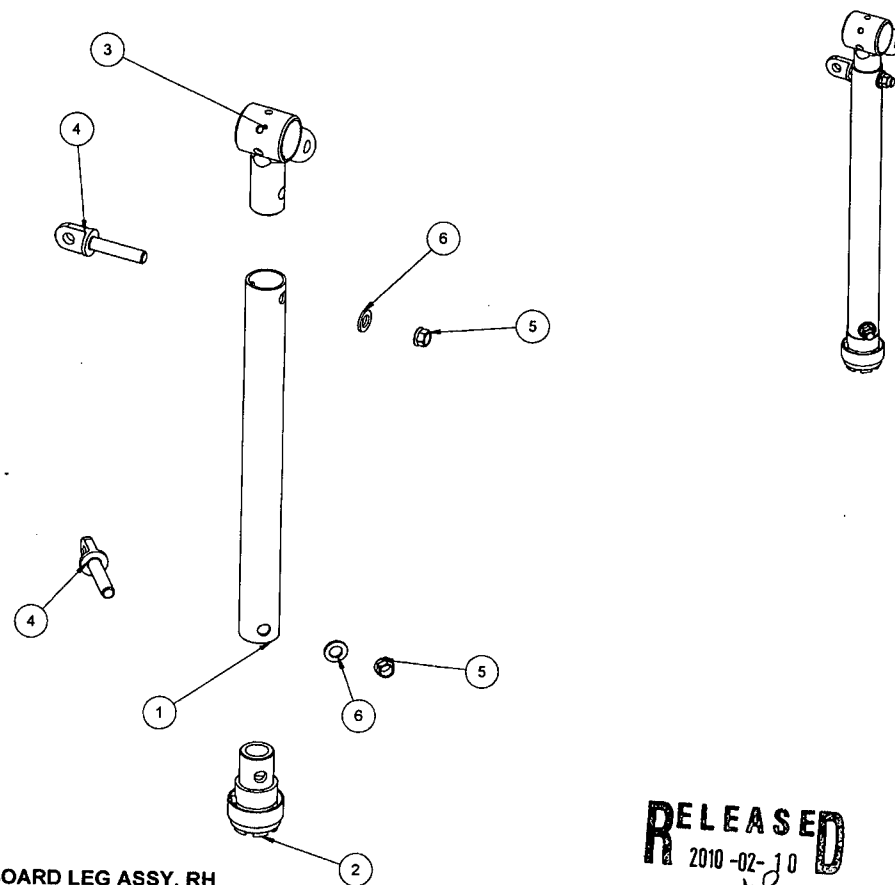
RELEASED
2010-02-10
JNP

D3782-043 FRONT OUTBOARD LEG ASSY, LH

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.42 lbs

DESIGN	10/1	DART AEROSPACE LTD	
DRAWN	10/1	HAWKESBURY, ONTARIO, CANADA	
CHECKED	10/1	DRAWING NO.	REV. B
MFG. APPR.	10/1	D3782	SHEET 2 OF 4
APPROVED	10/1	TITLE	SCALE
DE APPR.	10/1	LEG ASSEMBLY	NTS
DATE	10.01.21	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

ITEM NO.	QTY. (-044)	PART NUMBER	DESCRIPTION
1	1	D3768-4	FRONT OUTBOARD LEG, RH
2	1	D3787-1	FOOT
3	1	D3762-041	FRONT LEG FITTING ASSY
4	2	AN45-13A	EYE BOLT
5	2	MS21042L5	NUT
6	2	NAS1149D0563J	WASHER (AN960JD516)



D3782-044 FRONT OUTBOARD LEG ASSY, RH

RELEASED
2010-02-10

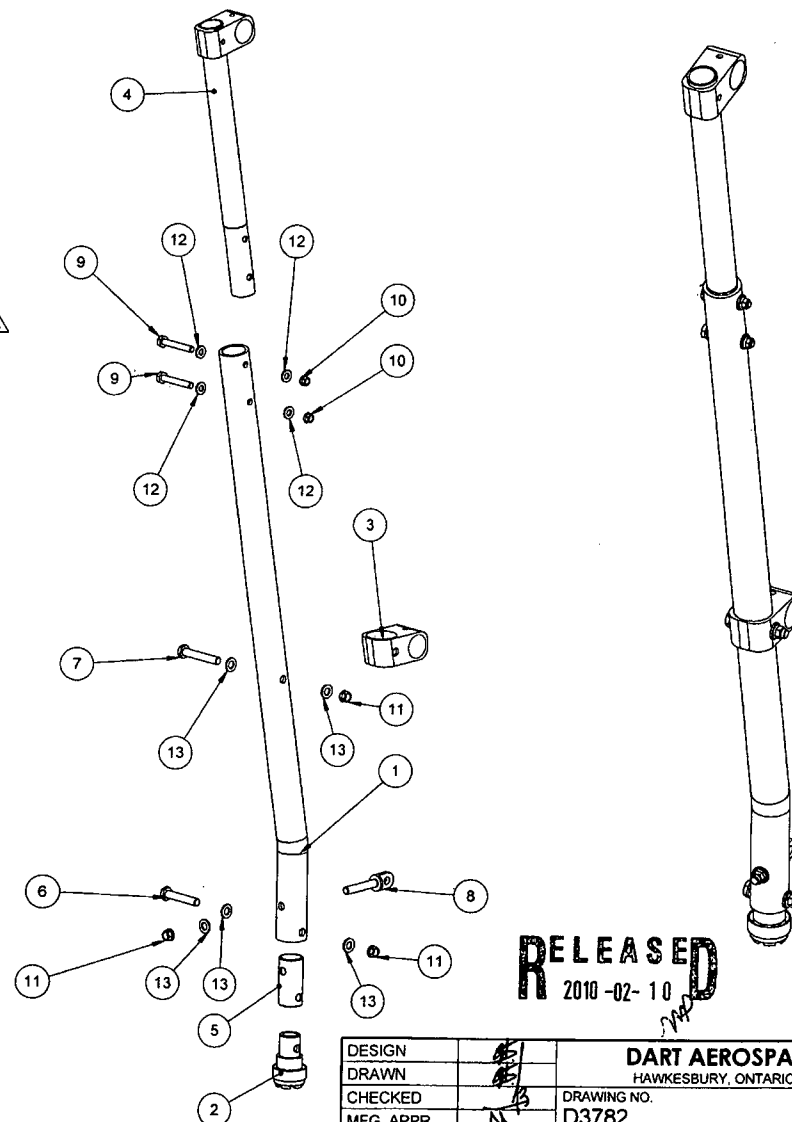
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs

DESIGN	AS	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. B
MFG. APPR.	N	D3782	SHEET 3 OF 4
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	LEG ASSEMBLY	NTS
DATE	10.01.21	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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ITEM NO.	QTY. (-045)	PART NUMBER	DESCRIPTION
1	1	D3772-1	BACK LEG
2	1	D3787-1	FOOT
3	1	D3784-1	BACK LEG FITTING
4	1	D3773-041	HEAD REST ADAPTER ASSY
5	1	D3786-1	SLEEVE
6	1	AN5-15A	BOLT
7	1	AN5-17A	BOLT
8	1	AN45-15A	EYE BOLT
9	2	AN4-15A	BOLT
10	2	MS21042L4	NUT
11	3	MS21042L5	NUT
12	4	NAS1149D0463J	WASHER (AN960JD416)
13	5	NAS1149D0563J	WASHER (AN960JD516)

D3782-045 BACK LEG ASSY



NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 4.71 lbs

RELEASED
 2010-02-10

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3782 TITLE LEG ASSEMBLY DATE 10.01.21	REV. B
DRAWN			SHEET 4 OF 4
CHECKED			SCALE
MFG. APPR.			NTS
APPROVED			
DE APPR.			
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